

# Aero Design Ltd.

## Work Order Control Sheet

Work Order#: 2017-177 Date Opened: 31 October 2017 Title: Fabrication

Aircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Handle Assembly Product Model: Ski Quantity: 4

### Work Order Contents

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

|       |
|-------|
| CB/JC |
| N/A   |
| CB/JC |
| N/A   |
| N/A   |
| N/A   |
| N/A   |
| N/A   |

### Component Completion

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

|     |
|-----|
| 4/4 |
| N/A |
| N/A |
| N/A |

### Build Sheet Contents

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

|       |
|-------|
| CB/JC |
| CB/JC |

### Certification

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

|       |
|-------|
| N/A   |
| CB/JC |
| N/A   |
| N/A   |
| CB/JC |

### Drawing List

| Drawing # | Rev # | Description         | Initial or N/A |
|-----------|-------|---------------------|----------------|
| 84261     | 2     | Handle Bar Assembly | CB/JC          |
|           |       |                     |                |
|           |       |                     |                |
|           |       |                     |                |
|           |       |                     |                |
|           |       |                     |                |
|           |       |                     |                |

### Additional Documentation

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

|     |
|-----|
| N/A |
| N/A |
| N/A |

### Billing

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

|     |
|-----|
| JC  |
| N/A |
| N/A |

### Traveller

Initial or N/A

|  |
|--|
|  |
|  |
|  |
|  |
|  |
|  |
|  |

Work performed by:

Print: David Martyn

Sign: 

SCA: AD05

Date: 31-Oct-17

ICC / Dual Inspection performed by:

Print: Jeff Clarke

Sign: 

SCA: AD02

Date: 2-Nov-17

Work Order closed by:

Print: Clay Brander/Jeff Clarke

Sign: 

SCA: AD02

Date: 2-Nov-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



## Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Lever Assy. R/H No. of pieces: 6

Manufacturer: Aero Design Ltd.

Part No.: 84261-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-65

Remaining Tasks to be Performed: weld in place

Signature: David Smith

Date: Aug 29 / 2017 Lic. No. / SCA 7304

In Process



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AMF 73-04

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Manufacturer: Aero Design Ltd.

Part No.: 84261-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-65

Remaining Tasks to be Performed: weld in place

Signature: Dan Mart

Date: Aug 29/2017 Lic. No. / SCA 7304

In Process

## CARGO BASKET HANDLE FABRICATION

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2017-177

QTY 4 AS350 ski

Complete  
(initial or SCA #)

Date Open: 31 Oct. 2017

PCW - WO 2017-65

1. Weld Lever Assembly – handle lever jig required
  - a. Set MS20615-4M3 monel rivet into socket in jig
  - b. Set 36274-01 bushing into socket in jig
  - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
  - d. TIG weld around bushing using ER308L rod.
  - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
  - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
  - g. Record material POs on attached material list.

PCW - WO 2017-65

2. Clean up
  - a. Clean lever assembly by media blasting with glass bead.
  - b. Drill out lever bushing to O (0.316) on lathe:
    - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
    - ii. Run at 300 RPM.
    - iii. Apply a drop of Rapid-Tap to drill.
  - c. De-burr.

3. Fabricate Handle Assembly
  - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
  - b. Measure across TOP side of levers.
  - c. Cut handle tubing to length measured.
    - i. Handles under 40" long: 1.0" x 0.035 round tube
    - ii. Handles over 40" long: 1.0" x 0.065 round tube
  - d. De-burr tube.
  - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
  - f. Record material PO on attached material list.

4. Weld Handle Assembly
  - a. Fuse tube to lever on both ends. Ensure levers are parallel.

5. Clean up
  - a. Clean welded area with scotch-brite.

6. Final Inspection –

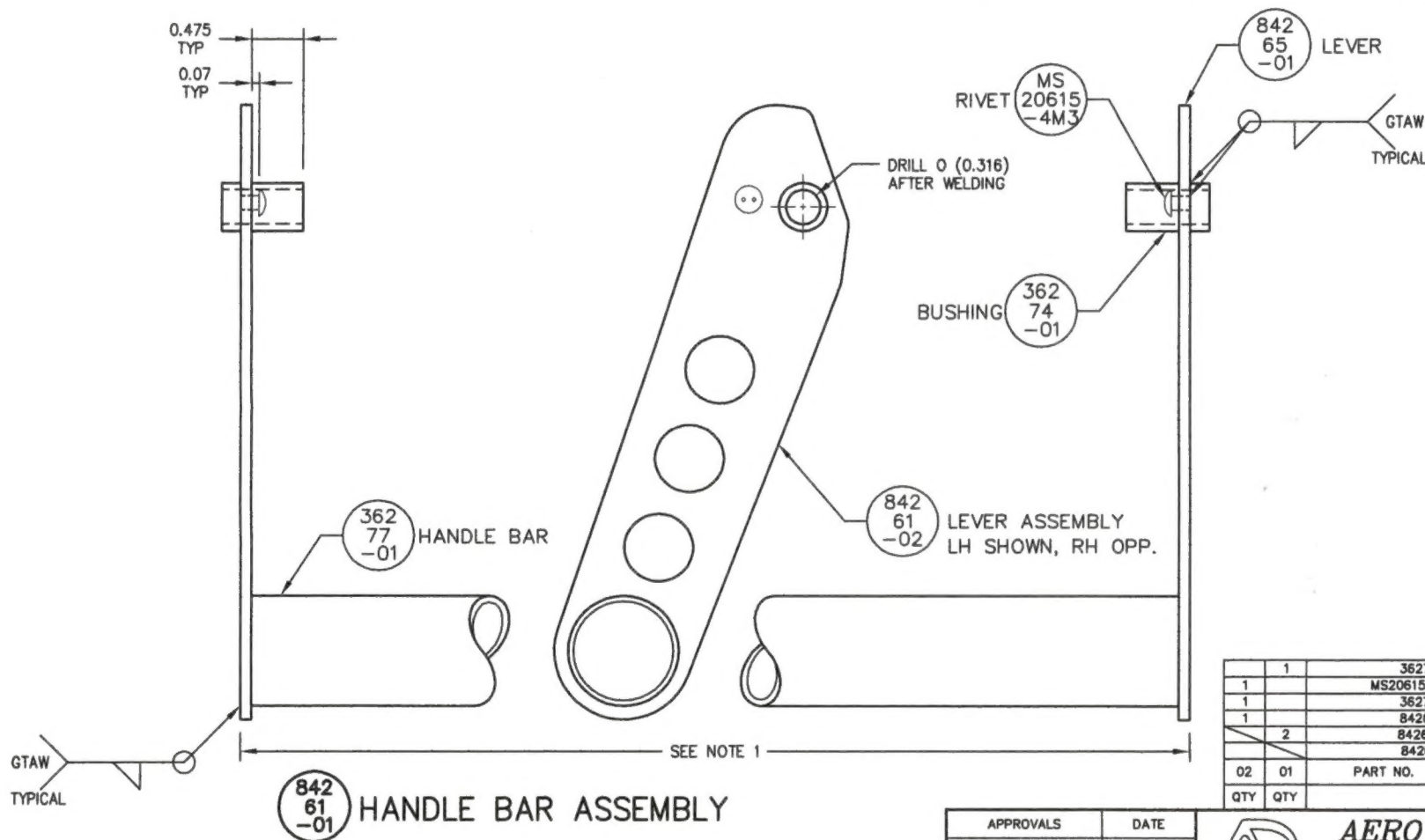
To be completed by a different person than the previous steps.

  - a. Welds for complete and handle for fit.
  - b. Tag complete and inspected parts in preparation for installation.



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| REV. | DESCRIPTION OF CHANGE                            | INITIALS | DATE       |
|------|--|----------|------------|
| 0    | INITIAL ISSUE                                    |          |            |
| 1    | HANDLE END BRACKETS FLIPPED                      | BJC      | SEPT 19/11 |
| 2    | TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N | BJC      | MAR 13/14  |



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

| QTY | QTY | PART NO.    | DESCRIPTION            |
|-----|-----|-------------|------------------------|
| 1   |     | 36277-01    | HANDLE BAR             |
| 1   |     | MS20615-4M3 | RIVET (MONEL)          |
| 1   |     | 36274-01    | BUSHING                |
| 1   |     | 84265-01    | LEVER                  |
| 2   |     | 84261-02    | LEVER ASSEMBLY (RH/LH) |
| 2   |     | 84261-01    | HANDLE BAR ASSY        |

| APPROVALS           | DATE       |
|---------------------|------------|
| DRAWN: R. RATHWELL  | JUNE 18/09 |
| CHECKED: E. BURGAIN |            |

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

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**HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY**

| SCALE        | DWG. SIZE | DWG. NO. | REV. |
|--------------|-----------|----------|------|
| SCALE 1 : 1  | A3        | 84261    | 2    |
| SHEET 1 OF 1 |           |          |      |

Work Order: 2017-177Date Opened: 31 Oct. 2017Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Handle Assembly

1 of 1

| Ass'y Step | Qty        | Detail Drawing | Part Number | Description                 | Material                               | PO/WO   |
|------------|------------|----------------|-------------|-----------------------------|--|---------|
|            | <u>549</u> | 84261          | 84261-01    | Handle Assembly             |  |         |
| Step 1     |            |                |             | Weld Lever Assembly         |  | 2017-65 |
|            | . 2        |                | 84265-01    | Lever                       | 304 Stainless, 0.105 Sheet             |         |
|            | . 2        |                | 36274-01    | Bushing                     | 304 Stainless, 7/16" x 0.065 Rnd. Tube |         |
|            | . 2        |                | MS20615-4M3 | Rivet                       |  |         |
|            | . A/R      |                |             | Welding Rod                 | ER308L TIG Rod                         |         |
| Step 2     |            |                |             | Clean Up                    | None                                   |         |
| Step 3     |            |                |             | Fabricate Handle Bar        |  |         |
|            | . 1        |                | 36277-01    | Handle Bar                  | 316 Stainless, 1.0 x 0.065 Rnd. Tube   | 17050   |
| Step 4     |            |                |             | Weld Handle Assembly        | None - Fuse weld, no rod req.          |         |
| Step 5     |            |                |             | Clean Up                    | None                                   |         |
| Step 6     |            |                |             | Inspection - Final Assembly | None                                   |         |